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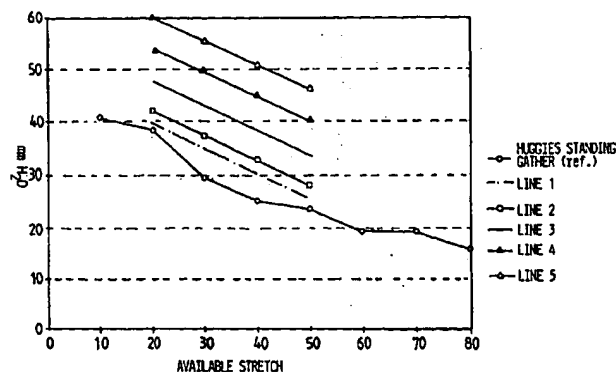
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(54) Title: AN ABSORBENT ARTICLE THAT INCLUDES A LIQUID BARRIER WITH IMPROVED SEALING



(57) Abstract

A method of improving in an oblong absorbent article that includes a liquid-impermeable bottom sheet, an upper liquid-permeable sheet and an absorbent body disposed between these sheets, and on each side of the longitudinal center line of the upper sheet at least one longitudinal elastic liquid barrier, the sealing effect afforded against the skin of the wearer by at least one liquid barrier on each side of said centre line by causing the absolute value of the negative product $2\gamma \cos\theta m/r$ in this liquid barrier to increase. A method of increasing in an absorbent article that includes an essentially liquid-impermeable top sheet above an absorbent body enclosed between an upper liquid-permeable sheet and a liquid-impermeable sheet, the top sheet being provided with elastic for shaping the article to the wearer's body and incorporating apertures intended to register with the anus and the urethra orifice of a wearer in use, around which apertures elastically puckered sealing edges are disposed, the absolute value of the negative product $2\gamma \cos\theta m/r$ for at least one sealing edge. An absorbent article where the absolute value of the product $2\gamma \cos\theta m/r$ for at least one liquid barrier on each side of the centre line of the absorbent body or for at least one sealing barrier lies above the line $y=kx+m$, where x designates the available elongation, k has the value $-14/30$ and m has the value 48 within the major part of an available elongation range of between 20 and 40 %.

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AN ABSORBENT ARTICLE THAT INCLUDES A LIQUID BARRIER WITH IMPROVED SEALING

5 The present invention relates to absorbent articles, such as diapers or incontinence guards, that provide a better sealing effect against the wearer's skin than earlier known articles of this kind. The invention also relates to a method of producing such articles.

10 An absorbent article of the kind to which the invention relates will include a liquid-impermeable sheet which is intended to lie distal from the wearer in use, an absorbent body, and an upper liquid-permeable sheet which lies proximal to the wearer in use. When the absorbent article concerned is a diaper or an incontinence guard, the article will also include flexible side flaps or wings that extend laterally beyond the absorbent body on both sides thereof and elastic devices that extend
15 longitudinally along the free side-edges of the side-flaps at least within that part which is intended to form the crotch part of the article in use, said flaps and elastic devices enabling the absorbent article to be fitted to the wearer. These elastic devices function as leg elastic when the article is worn. Thus, when the article is donned, the elastic elements will be stretched and hold the side flaps tightly against
20 the wearer.

Present-day absorbent articles have a very high absorbency and can also retain liquid under pressure. The greatest problems occur in the event of rapid liquid discharges. In such cases, it is necessary for a large volume of liquid to pass first
25 through the top liquid-permeable sheet and then be absorbed by and dispersed in the absorbent body. This does not take place instantaneously. The time taken for the liquid to pass through the top sheet may be from about one to two minutes, during which time liquid will run out to the edges of the article and leak therefrom. These problems are addressed with the aid of so-called liquid barriers or inner cuffs or
30 side-flaps that are intended to resist liquid leakage in the event of rapid liquid discharges. The originally used cuffs were intended primarily to retain faeces and

were formed by folding a part of the liquid-permeable top sheet around an elastic thread. In recent times, manufacturers have begun to produce the cuffs from a liquid-impervious material so as to also retain liquid.

5 When the leg elastic on the absorbent article is stretched and the article fastened on the wearer, the elastic element of the liquid barriers will also be stretched, thereby raising the barriers up. The elastic element of the barriers will hold the barrier edges under tension against the wearer. The upstanding liquid barriers then form beneath the wearer a "trough" in which a rapidly discharged large volume of urine can be
10 accommodated during the time required for the liquid to pass through the top liquid-permeable sheet. Attempts to improve the effectiveness of such liquid barriers have hitherto been directed towards the use of denser materials and towards flaps of sufficiently large size.

15 One drawback, however, is that liquid will rise above the brim of the barriers and leak out when the volume of liquid discharged is excessive or when the wearer sits or lies so as to press together the space between the upstanding liquid barriers.

Thus, current absorbent articles, such as diapers or incontinence guards, may
20 include along the outer longitudinal edges of the article sealing edges that are intended to lie tightly around the wearer's thighs and shape the article to the wearer's body, as well as a pair of inner cuffs or liquid-barriers which lie inwardly of the outer longitudinal edges and which are intended to form an impervious barrier against rapidly discharged liquid that is not absorbed immediately by the absorbent
25 body of said article. These inner cuffs shall thus be capable of withstanding a relatively high liquid pressure over a limited period of time of the order of a minute or so. The liquid has been absorbed by the absorbent body when this time period has lapsed. Also available are articles which include transverse cuffs that seal-off the transverse edges of the absorbent body.

Absorbent articles which lack the aforescribed inner liquid barriers are also available. In such cases, the outer longitudinal sealing edges form the sole liquid barriers of the absorbent body.

5 Also available are absorbent articles which include a liquid-impermeable sheet that is intended to lie proximal to the wearer in use and that includes elastic threads for shaping the article to the wearer's body. This liquid-impermeable sheet includes at least one aperture for register with the wearer's anus and urethra orifices. Elastic is provided around at least a part of the circumference of the aperture or apertures so
10 as to shape the edges of the aperture to the wearer and to form a seal. Situated beneath the liquid-impermeable sheet is an absorbent body which is enclosed between a liquid-permeable sheet and a liquid-impermeable sheet, such that the absorbent body will hang down beneath the wearer with the liquid-impermeable sheet lying distal therefrom.

15 The inner cuffs are comprised partly of a thin barrier sheet of essentially liquid-impervious inelastic material, e.g. nonwoven, and partly an elastic device which puckers that edge of the liquid barrier which lies against the wearer. The unresilient and inelastic material is fastened along one longitudinal edge either to the top
20 liquid-permeable sheet of the absorbent article so that no liquid can pass between the two sheets, or to the bottom liquid-impervious sheet along a side edge of the article. The elastic device is fastened along the other edge of the unresilient material, so as to gather the liquid barrier together and therewith form a puckered edge, which will be extended partially when the article is donned. Puckering of this
25 edge is normally achieved with an elastic thread placed in a channel in the inelastic material, said channel being formed by folding over and welding one edge of the material. When the absorbent article is donned, the puckered edge will be stretched partially, the extent of this stretch being dependent on the size of the wearer and how the article is donned.

The described liquid barriers or leg elastic cannot be used in absorbent articles held against the body of the wearer by special elastic pants or panties. These absorbent articles may comprise other sealing edges which are not stretched and held tensioned against the body. Thus, EP-A1-0 534 488 describes sealing gaskets which are preformed to extend outward from the central part of an absorbent article, which is illustrated by a sanitary napkin in the description of the preferred embodiment. The gaskets may be formed by looping a strip of material, such as a non-woven material, so as to form a compliant cuff which bears against the user's body in a comfortable manner. In one embodiment the gaskets are attached directly to the edges of the absorbent article, one edge of the gasket strip being attached to the upper sheet of the absorbent article and the other edge to the lower sheet. The looping of the material forms cavities for imparting compliancy and stability to the gaskets and the looping may also enclose elastic elements that are placed in tension when applied to the article so as to impart an arcuate shape to the article.

In another embodiment the gasket material is an elastic material which is attached to the longitudinally edges of the sanitary napkin. The material is placed in tension when applied to the sanitary napkin. The purpose of doing so is to impart an arcuate shape to the article.

The sanitary napkin is placed in a panty crotch during use and is pressed against the wearer by the force from the panty. Thus, the force applied from the sanitary napkin against the wearer is indirectly caused by pressure from the panty. The gasket embodiments including elastic elements do not cause the force against the body of the wearer. The purpose of the elastic elements are, if they are used, to impart an arcuate shape. This differs from the diaper or incontinence guard according to the invention with a barrier element including an elastic device, wherein the barrier element will get stretched against the wearer during use and thereby creating a liquid barrier with a good sealing effect. It is the body of the user which makes the elastic device in the barrier to get tensioned.

The object of the present invention is to provide a method of improving the ability of an absorbent article comprising leg elastic to remain tight against a wearer, with the aid of various measures. Another object of the invention is to provide an absorbent article comprising leg elastic and having improved sealing properties with respect to the wearer of the article.

The invention will now be described with reference to the accompanying drawings, in which

Figs. 1a, b, c illustrate measuring equipment used to determine the leakage pressure or breakthrough pressure for an elastic barrier material. Fig 1a shows the equipment without any applied material, Fig 1b shows the equipment with material applied in a stretched state, and Fig. 1c is a principle illustration of how the leakage pressure is determined;

Figs. 2a, b illustrate schematically a pore in a liquid barrier and the principle of determining the weighted mean value $\cos \theta_m$ and determining the radius r ; Fig. 3a illustrates a conventional diaper or incontinence guard with upstanding liquid barriers;

Figs. 3b, c are enlarged principle views of a section through the region B in Fig. 3a, firstly with respect to a conventional diaper (3b) and secondly for an embodiment of the invention (3c);

Figs. 4a, b illustrate the principle of calculating the available elongation or stretch; Fig. 5a is a graphic illustration showing the measured breakthrough pressures for three different liquid barriers;

Fig. 5b is a comparison diagram illustrating calculated and measured breakthrough pressures for the best liquid barrier in Fig. 5a, at different available degrees of elongation;

Fig. 5c is a diagrammatic illustration of lowest breakthrough pressures for liquid barriers constructed in accordance with the invention;

Fig. 6a is a graphic illustration of the measured breakthrough pressures for a conventional upstanding liquid barrier on the one hand and for two embodiments of the invention on the other hand;

Fig. 6b is a comparison diagram illustrating calculated and measured breakthrough pressures at different available elongations for one of the inventive embodiments shown in Fig. 6a;

Fig. 7 illustrates the measured breakthrough pressures for a conventional upstanding liquid barrier on the one hand and for a further embodiment of the invention on the other hand;

Figs. 8-14 are reproductions of photographs taken with an electron microscope of different liquid barriers at different available elongations; and

Figs. 8a-12a are views corresponding to the photograph reproductions in Figs. 8-12.

An absorbent article, such as a diaper, is manufactured for use by persons of different sizes. This is achieved by gathering together, or puckering, liquid barriers and side-edges with the aid of elastic. These liquid barriers and side-edges will stretch to different extents in accordance with the size of the wearer, and the tension around the edge of the barrier will thus vary in dependence on the size of the wearer.

Tension in the barrier elastic can be expected to have significance in studies on the sealing property of a liquid barrier, and consequently the extent to which the barrier is stretched will also be significant. A significantly stretched barrier will exert significant tension against the wearer's skin and can be expected to provide a better seal than corresponding barriers that are stretched to a lesser extent. One wish in this respect has been to produce the highest possible tension in the liquid barrier and therewith obtain the best possible sealing effect. However, it is not possible to use elastic in which the tension is excessively high, since the absorbent article will then be uncomfortable to wear and leave marks in the skin.

The term "available elongation or stretch" can be used when considering the extent to which a liquid barrier is stretched.

5 In the manufacture of the absorbent article, e.g. a diaper, the elastic material, which has a given degree of stretchability, is "locked" firmly to remaining non-stretchable material, normally nonwoven. The extent to which the elastic material is stretched in the manufacture of the article cannot be exceeded when the article is in use, since the elastic material is firmly secured to a non-stretchable material. This is shown in Fig. 4a. The elastic material has the length L at this point.

10

The non-stretchable material to which the elastic material is locked is puckered somewhat when the diaper is placed on the wearer's body. The elastic material has then contracted to the smaller length L_x .

15

The available stretch or elongation X is the extent to which the material can be stretched from the user state to the maximum stretched state of the product. This can be expressed by the formula: $L = L_x ((X/100) + 1)$, where X is the available stretch or elongation in percent.

20

Test equipment was constructed with the intention of studying the sealing effect achieved between a liquid barrier or some other puckered barrier and the wearer's skin. This equipment is shown in Figs. 1a, 1b and 1c and comprises a Plexiglas stand which includes a base plate a and an upstanding support plate b . A first upwardly open, semi-cylindrical element 1 is fastened horizontally to the upstanding support plate b and has around its periphery a scale which denotes the available elongation or stretch. One end of the semi-cylindrical element is attached to the support plate while the other end has an end-wall $1'$. Provided at the very bottom of the semi-cylindrical element 1 is a hole 2 to which a vertically upstanding filling tube 3 and an inclined measuring tube 4 lead, both of said tubes having a scale expressed in mm water. The equipment also includes a loose second semi-cylindrical element 5 whose diameter is somewhat larger than the diameter of the

25

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first semi-cylindrical element 1 and which has one side open and an end-wall 5' at its other end.

As shown in Fig. 1b, a measuring operation is carried out by securing a liquid
5 barrier around the outer periphery of the first semi-cylindrical element and fastening said barrier around the upper edges. The elastic part 7 is directed towards the attachment of the semi-cylindrical element to the support plate b, and the liquid barrier material is folded around the end-wall 1' of the first semi-cylindrical element 1 on the other side. The elastic part is fastened along the scale on the semi-
10 cylindrical element so as to enable the available elongation or stretch to be read-off. The end-wall 5' of the second semi-cylindrical element 5 is placed against the end-wall 1' of the first semi-cylindrical element with said upfolded part of said barrier material located therebetween and pressed thereagainst with the aid of a clamp 10, such as to obtain a small clearance 9 between the cylindrical walls. Synthetic urine
15 is introduced through the vertical tube 3. The liquid barrier is first weighted down so as to fill the clearance between the semi-cylindrical elements. A liquid pressure is thereafter built-up against the elastic edge 7 at the same time as a liquid column is formed in the tubes 3, 4, where the pressure can be read-off. Liquid is introduced until leakage occurs at arrow B (Fig. 1c) at the breakthrough pressure.

20 Three available types of liquid barriers, Huggies standing gather, Pampers standing gather and Peaudouce leg elastic, have been studied with this equipment, the leakage tendency with the elastic element stretched to and locked at different available elongations being measured. The liquid pressure at which leakage will
25 occur in respect of a barrier stretched to a given extent, i.e. a barrier that has a given available elongation or stretch, has been determined with the aid of the test equipment, this pressure being found to vary in dependence on the extent to which the puckered edge is stretched. The measured values are shown in the diagram in Fig. 5a. As will be evident from the Figure, however, different barriers give
30 different breakthrough pressures at the same available stretch or elongation. It thus

appears that the sealing effect is influenced by other factors than solely the tension in the elastic material.

The invention is based on an attempt to provide an improved sealing effect on the basis of factors other than the actual tension in the elastic.

On the basis of the theory that leakage does not occur merely because the elastic in the barrier material releases its contact with the wearer's skin but first occurs through the through-penetrating pores or channels that are formed between the wearer's skin and the folds in the puckered edge of the barrier material, endeavours have been made to create a model from which the leakage pressure can be determined theoretically and thereby become aware of those parameters that shall be influenced in order to achieve a better sealing effect.

The capillary pressure of the pores in porous structures can be calculated with the Laplace equation.

According to Laplace, the capillary pressure $\Delta P = 2\gamma \cos\theta/r$, where γ is the surface tension of the liquid, θ is the wetting angle of the liquid to the material in the capillary walls, and r is the radius of the capillary. When θ is greater than 90° , $\cos\theta$ is negative and ΔP is consequently also negative. The capillary wall is hydrophobic and the resultant pressure ΔP can be said to describe the breakthrough pressure, i.e. the maximum pressure a capillary or pore can withstand. When θ is less than 90° , the capillary wall is hydrophilic and ΔP and $\cos\theta$ are positive. Liquid is then "sucked" into the pores.

When studying the pressure in a capillary or pore, where the wall consists of several materials, such as in a pore formed between skin and a fold in a liquid barrier, the proportion of circumference of each material must be weighed together so as to

provide a mean value of $\cos\theta$, hereinafter designated $\cos\theta_m$. The breakthrough pressure will then be $\Delta P = 2\gamma \cos\theta_m/r$.

5 In the present case, the walls of the pores consist partly of an hydrophilic material, i.e. skin, which has a wetting angle of less than 90° , and partly of the hydrophobic material in the liquid barrier, which has a wetting angle above 90° . $\cos\theta_m$ is the weighted mean value of the pore wall's $\cos\theta$ -values and is calculated in the manner illustrated in Fig. 2a, where A designates the circumference proportion hydrophobic wall and B designates the circumference proportion hydrophilic wall, where
10 $A + B = 1$. $\cos\theta_m$ will therewith equal $A \cdot \cos\theta_{\text{fob}} + B \cdot \cos\theta_{\text{fil}}$.

As described below, trials have been carried out with the intention of checking whether or not the described model can be used as a basis on which the breakthrough pressure can be evaluated.
15

The wetting angle of the skin varies in accordance with the state of the skin, i.e. whether the skin is clean or dirty, for instance. Measuring equipment comprised of Plexiglas with a wetting angle of 77° , which lies close to the mean value of the wetting angle of the skin (about 74°), was used for comparison purposes.
20 Measurement were carried out on the commercial liquid barrier that produced the best sealing result according to Fig. 5a, i.e. Huggies standing gather which has a wetting angle of 120° . The liquid used was synthetic urine. γ is the surface tension of synthetic urine, i.e. 0.06 N/m .

25 Abutment of a liquid barrier against the measuring equipment was studied at different available elongations with an electron microscope, enlargement 130 times, as illustrated in Figs. 8-12 and Figs. 8a-12a. As will be evident from the Figures, a through-penetrating pore is formed between the threads or fibres of the barrier material and the Plexiglas wall of the test equipment. This pore is assumed to

function as a capillary, where r = the radius of the largest possible circle that can be enclosed in the channel, as evident from Fig. 2b.

The through-penetrating pore has been drawn in Figs. 8a-12a. The following pore-radius values were obtained at different available elongations, as shown in the Figures.

Available Elongation	Pore Radius
10%	0.0208 mm
20%	0.0812 mm
30%	0.1208 mm
40%	0.1458 mm
50%	0.1458 mm

Comments: It was very difficult to measure the pore radius on the photograph at a 10% available elongation, and the value given is therefore perhaps unreliable.

The crosses shown in Figs. 8a-12a show the lateral terminal points of the pore intended for calculating the hydrophobic and hydrophilic length-proportions of the pore. The length ratio between hydrophobic and hydrophilic surfaces in the pore at different available elongations is shown in the following Table.

Avail. elong	Hydrophil. surface	Hydrophob. surface
10%	39%	61%
20%	39%	61%
30%	32%	68%
40%	39%	61%
50%	50%	50%

Calculations relating to "Huggies standing gather" against Plexiglas:

10% available elongation

$$\Delta P = 2 \cdot 0.06 \cdot (0.39 \cdot \cos 74^\circ + 0.61 \cdot \cos 120^\circ) / 0.0208 \cdot 10^{-3}$$

$$\Delta P = -1139 \text{ Pa} \Rightarrow \text{the absolute value of the breakthrough pressure} = 114 \text{ mm H}_2\text{O}$$

5 20% available elongation

$$\Delta P = 2 \cdot 0.06 \cdot (0.39 \cdot \cos 74^\circ + 0.61 \cdot \cos 120^\circ) / 0.0812 \cdot 10^{-3}$$

$$\Delta P = -291.9 \text{ Pa} \Rightarrow \text{the absolute value of the breakthrough pressure} = 29.2 \text{ mm H}_2\text{O}$$

30% available elongation

10
$$\Delta P = 2 \cdot 0.06 \cdot (0.32 \cdot \cos 74^\circ + 0.68 \cdot \cos 120^\circ) / 0.1208 \cdot 10^{-3}$$

$$\Delta P = -250.1 \text{ Pa} \Rightarrow \text{the absolute value of the breakthrough pressure} = 25.0 \text{ mm H}_2\text{O}$$

40% available elongation

$$\Delta P = 2 \cdot 0.06 \cdot (0.39 \cdot \cos 74^\circ + 0.61 \cdot \cos 120^\circ) / 0.1458 \cdot 10^{-3}$$

15
$$\Delta P = -162.6 \text{ Pa} \Rightarrow \text{the absolute value of the breakthrough pressure} = 16.3 \text{ mm H}_2\text{O}$$

50% available elongation

$$\Delta P = 2 \cdot 0.06 \cdot (0.5 \cdot \cos 74^\circ + 0.5 \cdot \cos 120^\circ) / 0.1458 \cdot 10^{-3}$$

$$\Delta P = -92.3 \text{ Pa} \Rightarrow \text{the absolute value of the breakthrough pressure} = 9.2 \text{ mm H}_2\text{O}$$

20

Fig. 5b shows a comparison between the breakthrough pressures measured with the test equipment and the breakthrough pressures calculated with the above formula.

Since the calculated and measured breakthrough pressures are in good agreement, it is thus possible to improve the sealing effect of the liquid barrier in an absorbent article against the wearer's skin by influencing $|\Delta P|$, i.e. $|(2\gamma \cos \theta m/r)|$, of the barrier so that this value increases. One provision in this respect is that the tension in the elastic will be sufficiently high to prevent the liquid barrier from allowing liquid to escape at a lower pressure as a result of the elastic relaxing and allowing

25

the barrier to "ease" away from the wearer by virtue of the liquid column weighing down the barrier so that it releases its contact with the abutment surface.

$|\Delta P|$ can be caused to increase by increasing the product $|2\gamma \cos\theta m/r|$

5

The invention thus relates to a method of improving the sealing ability of an absorbent article by causing the product $-(2\gamma \cos\theta m/r)$ of one or more of the liquid barriers of the article to increase.

10 The product can be increased by, for instance

- 1) influencing the wetting angle between the liquid to be sucked up and the skin or the barrier material, respectively;
- 2) influencing the pore radius, i.e. the capillary radius, formed between the barrier material and the skin; and
- 15 3) influencing both wetting angle and pore radius.

Because the effect intended is to increase the absolute value of the product

$2\gamma \cos\theta m/r$, it is not necessary to unilaterally increase $|\cos\theta m|$ or decrease r . It is

possible for a procedure of increasing $|\cos\theta m/r|$ to also involve simultaneous

20

increase of the radius. Provided that the increase in $|\cos\theta m|$ is proportionally greater than the increase in radius, an improved result will be obtained despite the increase in radius. Similarly, a procedure that decreases the radius may result in a decrease in $|\cos\theta m|$. An improved result will still be achieved, however, provided that this latter decrease is proportionally smaller than the decrease in radius.

25

The invention also relates to an absorbent article such as a diaper or an incontinence guard that has improved sealing properties against a user and which has been produced so that in the case of at least a pair of the liquid barriers of the article, the absolute value of the product $2\gamma \cos\theta m/r$ will be higher than that obtained when

30 using earlier known absorbent articles. More specifically, during the greater part of

the interval 20-40% available elongation or stretch, preferably during the major part of the interval between 15 and 50%, and particularly during the major part of the interval between 10 and 80% available elongation, the absolute value y of the product $2\gamma \cos\theta m/r$ will lie above line $y=kx+m$, where x designates the available elongation or stretch, k has the value $-14/30$ and m has the value 48 (line 1), preferably 51 (line 2), more preferably 57 (line 3) and even more preferably 63 (line 4) and in particular 69 (line 5). These lines are shown in Fig. 5c, in which the measured breakthrough pressure of the most effective liquid barrier known at present, i.e. the Huggies standing gather barrier, has been drawn by way of comparison.

The invention will now be described in more detail with reference to particular exemplifying embodiments and also with reference to the accompanying drawings.

Examples

Fig. 3a shows a conventional diaper or incontinence guard 20 which includes a liquid-permeable top sheet 22, an absorbent sheet 23, and a liquid-impermeable bottom sheet 21, said sheets being delimited by two transverse edges 24, 25 and two longitudinal edges 26, 27. The illustrated article also includes longitudinally extending leg elastic 28 and an upstanding liquid barrier 29 on each side of the longitudinal centre line. Fig. 3b is a sectional view that illustrates the construction of the upstanding liquid barrier comprising a liquid-impermeable sheet 12 whose free edge is curved around two stretched elastic threads 13. The threads 13 function to pucker the sheet 12.

Fig. 3c illustrates an embodiment of the invention in which the pore radius has been significantly reduced, and is constant and small already at high available elongation or stretch. In this case, the elastic threads 13 have been replaced by an elastic film

14. This film will lie essentially smoothly against the skin. The pore radius is close to 0 already at a high available elongation.

Fig. 14 is a reproduction of an electron microscope photograph of an inventive embodiment similar to the embodiment of Fig. 3c, in which an elastic film is used as the edge on the liquid barrier, stretched against the Plexiglas. The small pores that can be seen are the result of the film being a three-ply film in the illustrated case, where only the centre layer is elastic. The outer layers used to join the film to the barrier will crack when the centre layer is stretched, as shown in Fig. 15. The visible small pores, which have a radius of about 0.02 mm, will remain essentially constant irrespective of the available elongation, since the height of the pores is constant even though the length is changed. The uppermost curve in Fig. 7 illustrates measurements made with this liquid barrier. The lower curve shows the results obtained with a Huggies standing gather.

The wetting angle was changed in two tests. In the first case, a plastic film having a wetting angle of 97.5° was stretched over the first semi-cylindrical Plexiglas surface. This corresponds to a treatment of the barrier such that the wearer's skin will obtain a higher wetting angle. This is hydrophobic in distinction to the normal skin mean wetting angle of about 74° . The result of this change in the wetting angle (centre curve) is compared in Fig. 6a with the sealing effect achieved with the upstanding liquid barrier Huggies standing gather (lowermost curve). As the measuring values show, an improved sealing effect is achieved in this way.

The uppermost curve in Fig. 6a shows measurements obtained with a liquid barrier that had been treated with Vaseline. Vaseline has a wetting angle of 100° . The Vaseline partially blocks the pores, i.e. reduces the pore radius, and also smears the wearer's skin, thereby increasing the wetting angle of the liquid to the skin. As will be evident from the diagram shown in Fig. 6a, there is obtained a significant improvement that exceeds the improvement achieved when only the wetting angle of the skin is changed, despite obtaining, at the same time, a reduction in the wetting

angle of the barrier by virtue of the Vaseline also smearing the liquid barrier and therewith lowering its wetting angle from 120° to 100°.

5 Fig. 6b is a diagram in which the calculated and measured sealing effects obtained when changing the wetting angle are shown. The measured values have been obtained by covering the Plexiglas with the aforescribed plastic film, and corresponds to the centre curve in the diagram shown in Fig. 6a. Good agreement is obtained between the calculated and measured values.

10 As will be evident from the foregoing, the sealing effect provided by an absorbent article can be improved by treating at least one of its liquid barriers in a manner such as to cause the absolute value of the negative product $2\gamma \cos\theta m/r$ to increase at least within the major part of an available elongation range of 20-40%. The sealing effect of an article having a liquid barrier where the absolute value of the negative
15 product $2\gamma \cos\theta m/r$ lies above the line $y=kx+m$ at least within the major part of an available elongation range of 20-40%, where x designates the available elongation or stretch, k has the value -14/30 and m has the value 48, preferably 51, more preferably 57, and even more preferably 63 and particularly 69, will be substantially better than the sealing effect achieved with conventional articles of this nature.

20 The invention also relates to articles that have transverse liquid barriers, and to a method of treating such liquid barriers in the same manner as that described with respect to the longitudinally extending liquid barriers.

25 The longitudinally extending liquid barriers may be comprised of both leg elastic and inner cuffs.

It will be understood that the invention is not restricted to the described exemplifying embodiments thereof and that it includes all conceivable embodiments
30 that lie within the scope of the following Claims.

CLAIMS

1. A method of improving in an absorbent article such as a diaper or an incontinence guard that includes a liquid-impermeable sheet (21) which is intended to lie distal from the wearer in use, a top liquid-permeable sheet (22) which is intended to lie proximal to the wearer in use, an absorbent body (23) disposed between said sheets, and at least one longitudinally extending liquid barrier (28, 29) on each side of the centre line of said top sheet, said liquid barrier being comprised of essentially liquid-impervious material (12) and fastened along or adjacent to a respective longitudinally extending side edge of the article and comprising a free elastic edge intended to be stretched against the wearer in use, the sealing effect afforded against the skin of an intended wearer by at least one liquid barrier (28, 29) on each side of said centre line, characterized by causing the absolute value of the negative product $2\gamma \cos\theta m/r$ for said liquid barrier (28, 29) to increase, where γ designates the surface tension of the liquid to be absorbed by suction, r designates the radius of the largest circle that can be encompassed in any pore formed by the edge of the liquid barrier against the wearer's skin at a given available elongation, and $\cos\theta m$ is the weighted mean value of $\cos\theta$, where θ is the wetting angle of the liquid to the material in the pore walls, while taking into account the different materials in the walls of this largest pore.
2. A method of improving in an absorbent article which includes a liquid-impermeable sheet which is intended to lie against a wearer in use and which includes elastic for shaping the article to the wearer's body, and which sheet includes apertures intended to lie in register with the anus and the urethra orifice of the wearer, and around which apertures elastically puckered sealing edges are disposed in the essentially liquid-impermeable sheet, and which article includes an absorbent body on that side of the essentially liquid-impermeable sheet that lies distal from the wearer in use, and wherein said absorbent body is enclosed between a liquid-permeable sheet on the side proximal to the wearer, and a liquid-impermeable sheet, the sealing effect afforded against the skin of an intended

wearer by at least one sealing edge characterized by causing the absolute value of the negative product $2\gamma \cos\theta_m/r$ for at least one sealing edge to increase, where γ designates the surface tension of the liquid to be absorbed, r designates the radius of the largest circle that can be encompassed by any pore formed by the free sealing edge against a wearer at a given available elongation, and $\cos\theta_m$ is the weighted mean value of $\cos\theta$, where θ is the wetting angle of the liquid to the material in the pore walls, while taking into account the different materials in the walls of said largest pore.

3. A method according to Claim 1 or 2, characterized by causing the absolute value of the negative product $2\gamma \cos\theta_m/r$ to increase at least within the major part of an available elongation range of 20-40%.
4. A method according to any one of the preceding Claims, characterized by causing the absolute value of the negative product $2\gamma \cos\theta_m/r$ to increase by at least 5%, particularly by at least 15%, preferably by at least 25%, and then particularly by at least 35%.
5. A method according to any one of the preceding Claims, characterized by causing the pore radius of the liquid barrier to decrease at least at an available elongation above 60%, particularly at an available elongation above 50%, more particularly at an available elongation above 40% and then preferably at an available elongation above 20%.
6. A method according to any one of the preceding Claims, characterized by causing the absolute value of $\cos\theta_m$ to increase.
7. A method according to Claim 6, characterized by treating the barrier such that a higher wetting angle of the liquid to the barrier material will be obtained and/or such that a higher wetting angle of the liquid to the skin of the wearer will be

obtained within those regions in which the liquid barrier lies against the skin when the absorbent article is donned.

8. A method according to any one of the preceding Claims, characterized by providing the edge of the liquid barrier with a layer of material that increases the absolute value of $\cos\theta_m$ and/or that reduces r when the article is donned.

9. A method according to any one of Claims 1-7, characterized by causing the absolute value of the negative product $\cos\theta_m/r$ to increase.

10. An absorbent article that includes a liquid-impermeable sheet (21) which is intended to lie distal from the wearer in use, a top liquid-permeable sheet which is intended to lie proximal to the wearer in use, an absorbent body (23) disposed between said sheets, and at least one elastic liquid barrier (28, 29) on each side of the longitudinal centre line of the liquid-permeable sheet, said liquid barrier being comprised of essentially liquid-impervious material (12) fastened to the top liquid-permeable sheet along the longitudinally extending edge of the article, or to the liquid-impermeable sheet (22) at the longitudinally extending edges (26, 27) of said article, characterized in that in respect of at least one liquid barrier (28, 29) on each side of the centre line of said absorbent body the absolute value of the product $2\gamma \cos\theta_m/r$ lies above the line $y=kx+m$, where x designates the available elongation, k has the value $-14/30$ and m has the value 48, particularly 51, preferably 57, more preferably 63 and in particular 69, within the major part of an available elongation range of between 20 and 40% and where γ designates the surface tension of the liquid to be absorbed, r designates the radius of the largest circle that can be enclosed in any pore formed by the edge of the liquid barrier against the skin of the wearer at a given available elongation, and $\cos\theta_m$ is the weighted mean value of $\cos\theta$, where θ is the wetting angle of the liquid to the material in the pore walls while taking into account the different materials in the walls of the largest pore.

11. An absorbent article which includes an essentially liquid-impermeable sheet which is intended to lie proximal to the wearer in use and which includes elastic for shaping the article to the wearer's body, said sheet being provided with apertures which are intended to register with the anus and the urethra orifice of a wearer and
5 around which elastically puckered sealing edges are disposed in the essentially liquid-impermeable sheet, wherein an absorbent body is disposed on that side of the essentially liquid-impermeable sheet that lies distal from the wearer in use, wherein the absorbent body is enclosed between a liquid-permeable sheet on that side which lies proximal to the wearer, and a liquid-impermeable sheet, characterized in that
10 in respect of at least one sealing edge the absolute value of the product $2\gamma \cos\theta m/r$ lies above the line $y=kx+m$, where x designates the available elongation, k has the value $-14/30$ and m has the value 48, preferably 51, more preferably 57, even more preferably 63 and particularly 69, within the major part of an available elongation range of between 20 and 40%, and where γ designates the surface tension of the
15 liquid to be absorbed, r designates the radius of the largest circle that can be enclosed in any pore formed by the free sealing edge against the wearer's skin at a given available elongation and $\cos\theta m$ is the weighted mean value of $\cos\theta$, where θ is the wetting angle of the liquid to the material in the pore walls, while taking into account the different materials in the walls of the largest pore.

20

12. An article according to Claim 10 or 11, characterized in that the free edge of the barrier includes a layer of a material such that a higher wetting angle of the liquid to the barrier material will be obtained and/or such that a higher wetting angle of the liquid to the skin of the wearer will be obtained within those regions in which
25 the liquid barrier lies against the skin and where said material smears the skin when the absorbent article is donned.

13. An article according to any one of Claims 10-12, characterized in that the free edge of the barrier is provided with a layer of a material which at least partly
30 fills out the pores in said edge when the article is donned.

14. An article according to any one of Claims 10-13, **characterized** in that when the article is donned, the free edge of the barrier has a pore radius which is essentially independent of the available elongation or stretch and which is at most 0.10 mm, preferably at most 0.08 mm and most preferably at most 0.04 mm.

5

15. An article according to any one of Claims 10-14, **characterized** in that the free edge of the barrier is comprised of a ribbon-like elastic film.

10

16. An article according to any one of Claims 10-15, **characterized** in that the absolute value of the product $2\gamma \cos\theta m/r$ lies above the line $y=kx+m$ within the major part of an available elongation range of 15-50%, preferably within the major part of the range 10-60%.

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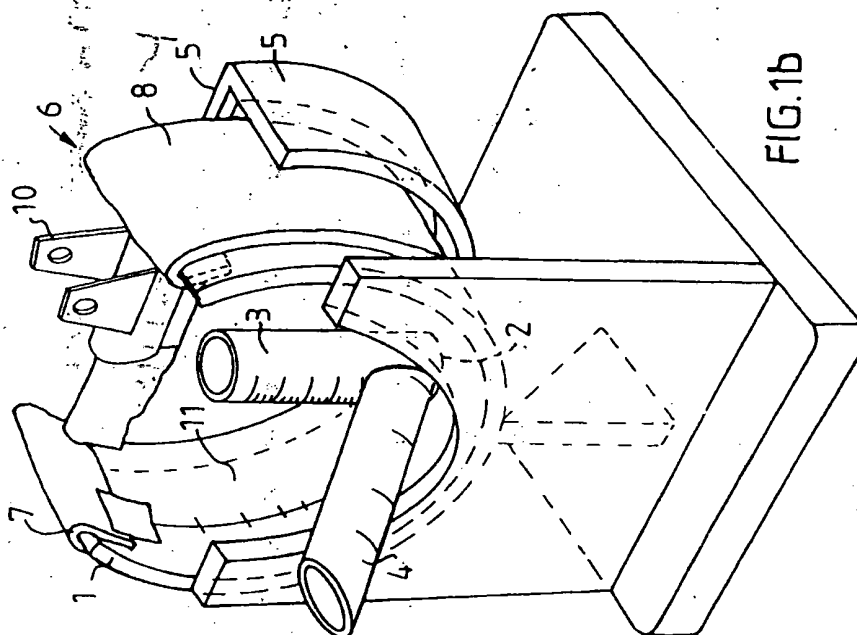


FIG. 1b

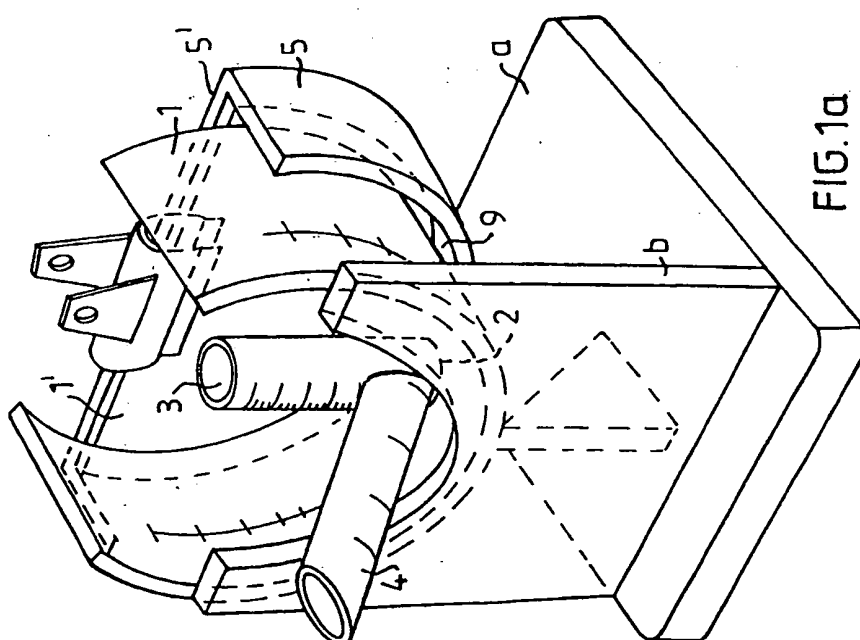


FIG. 1a

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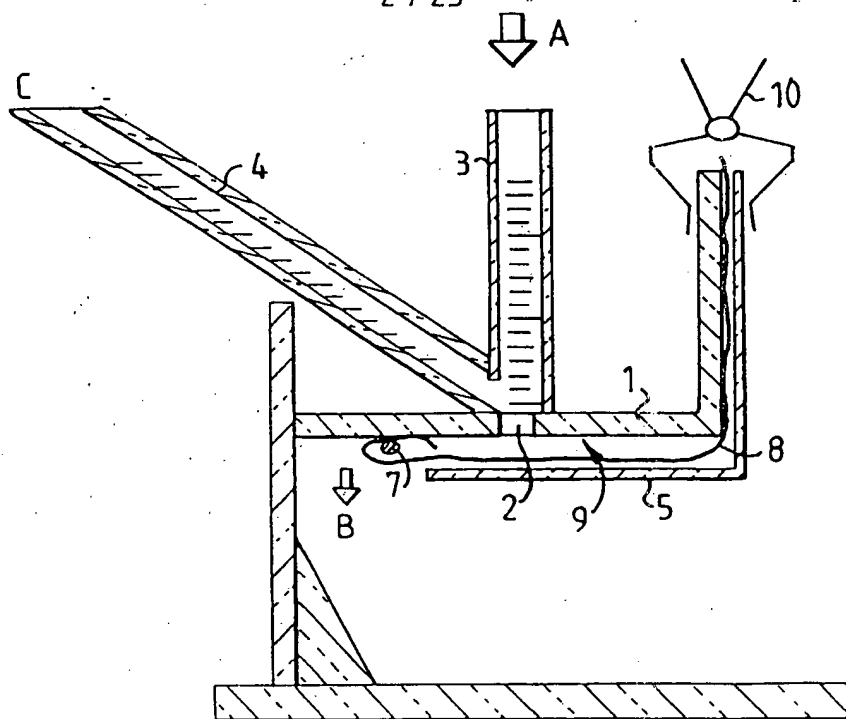


FIG. 1c

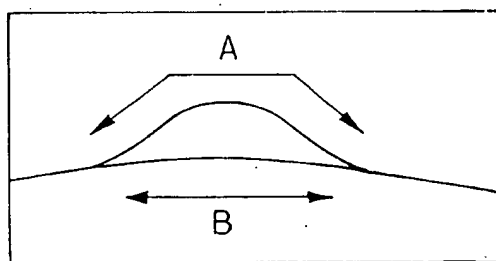


FIG. 2a

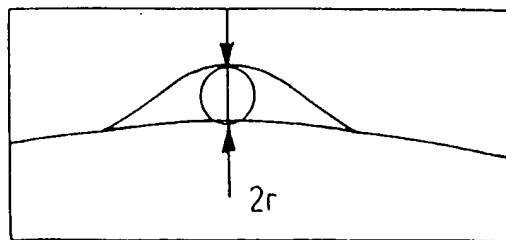
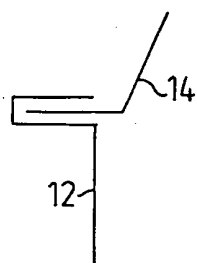
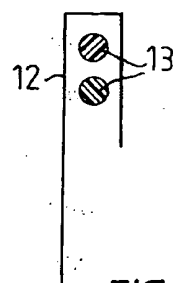
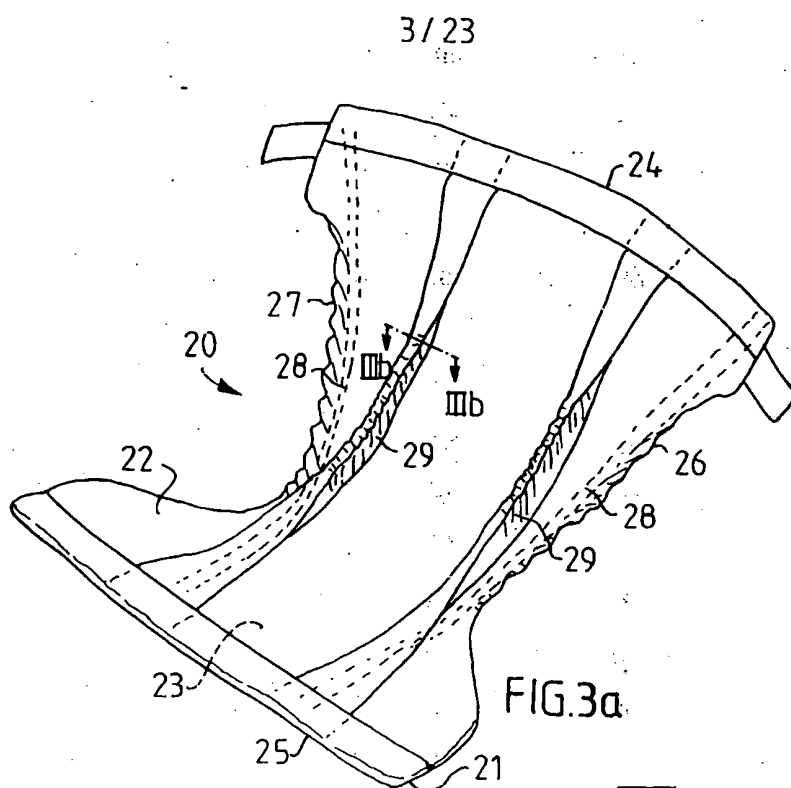


FIG. 2b



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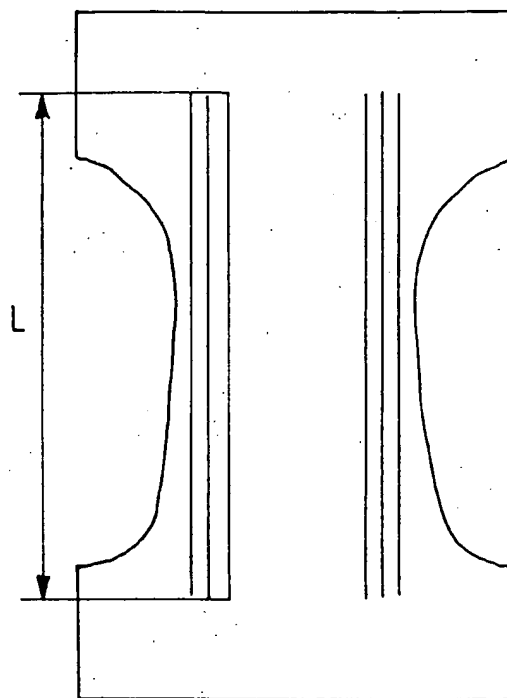


FIG. 4a

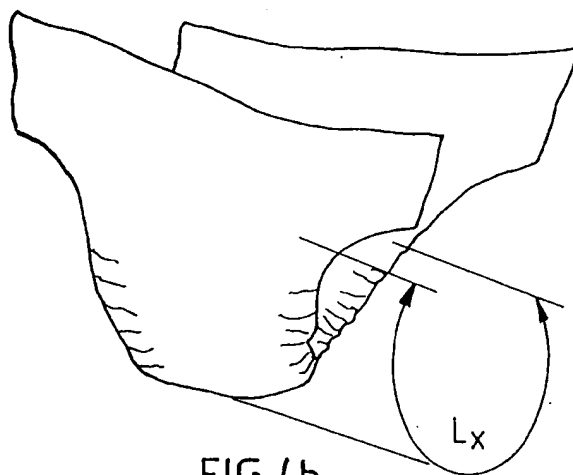


FIG. 4b

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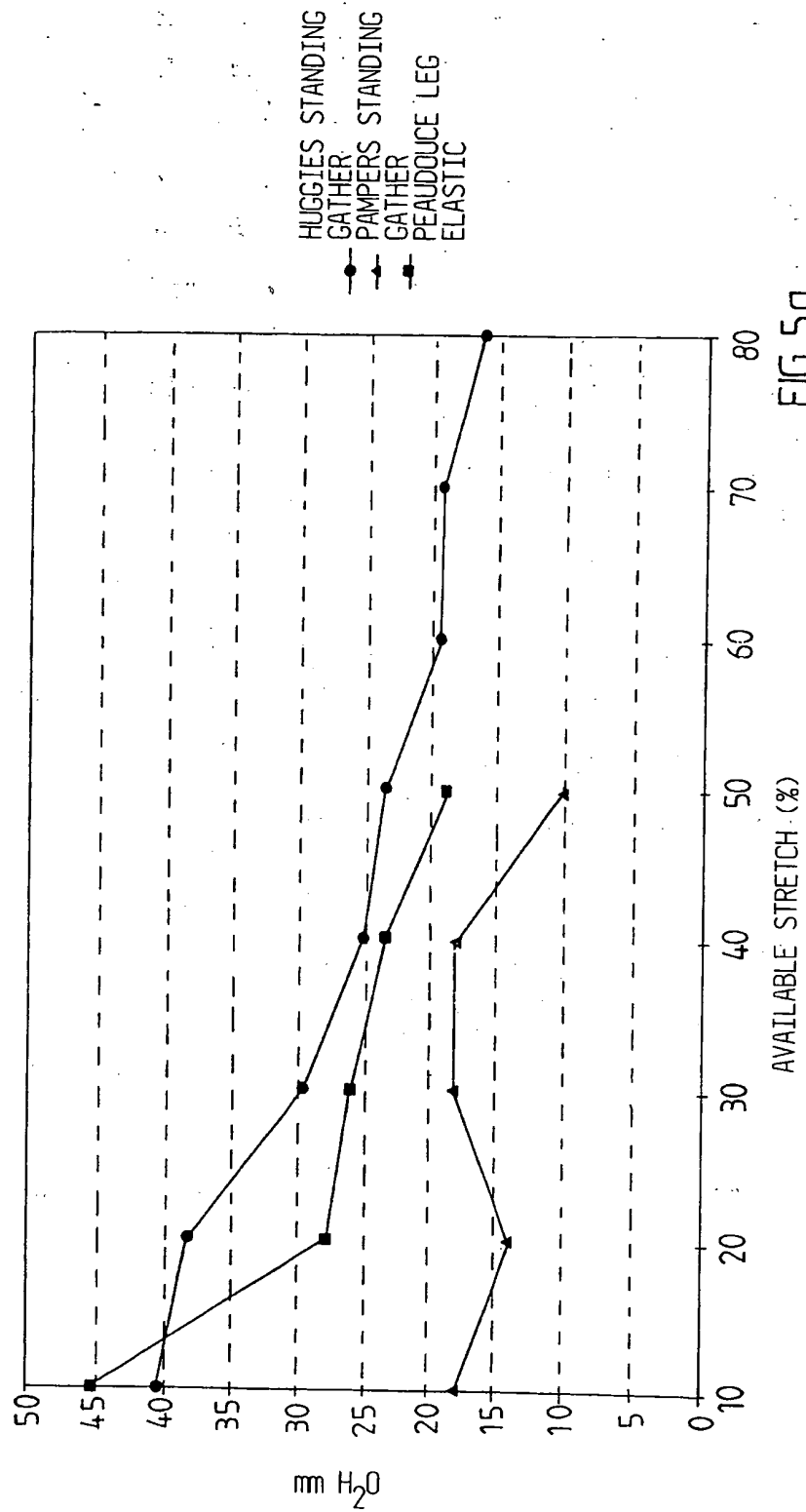


FIG. 5a

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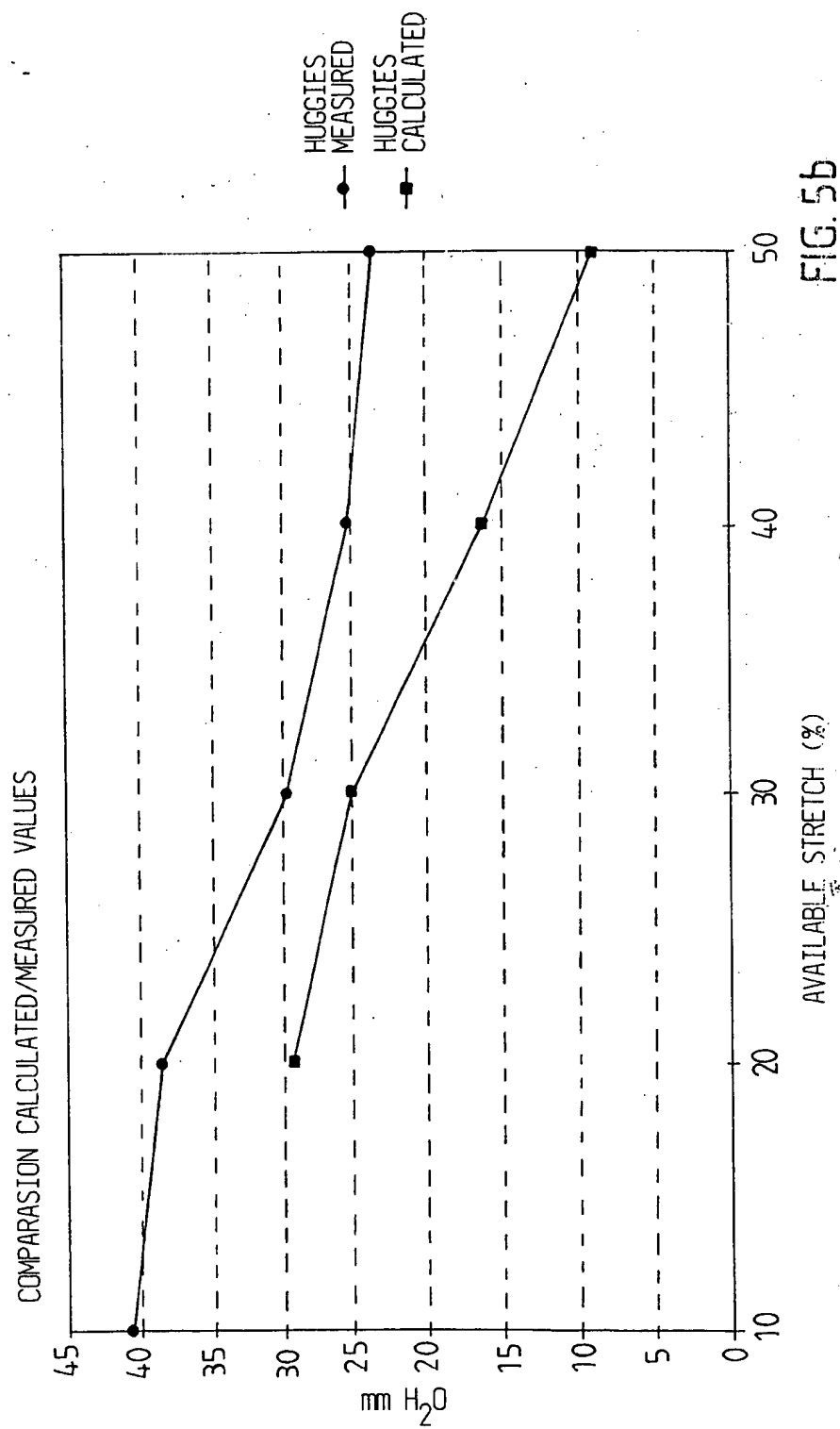


FIG. 5b

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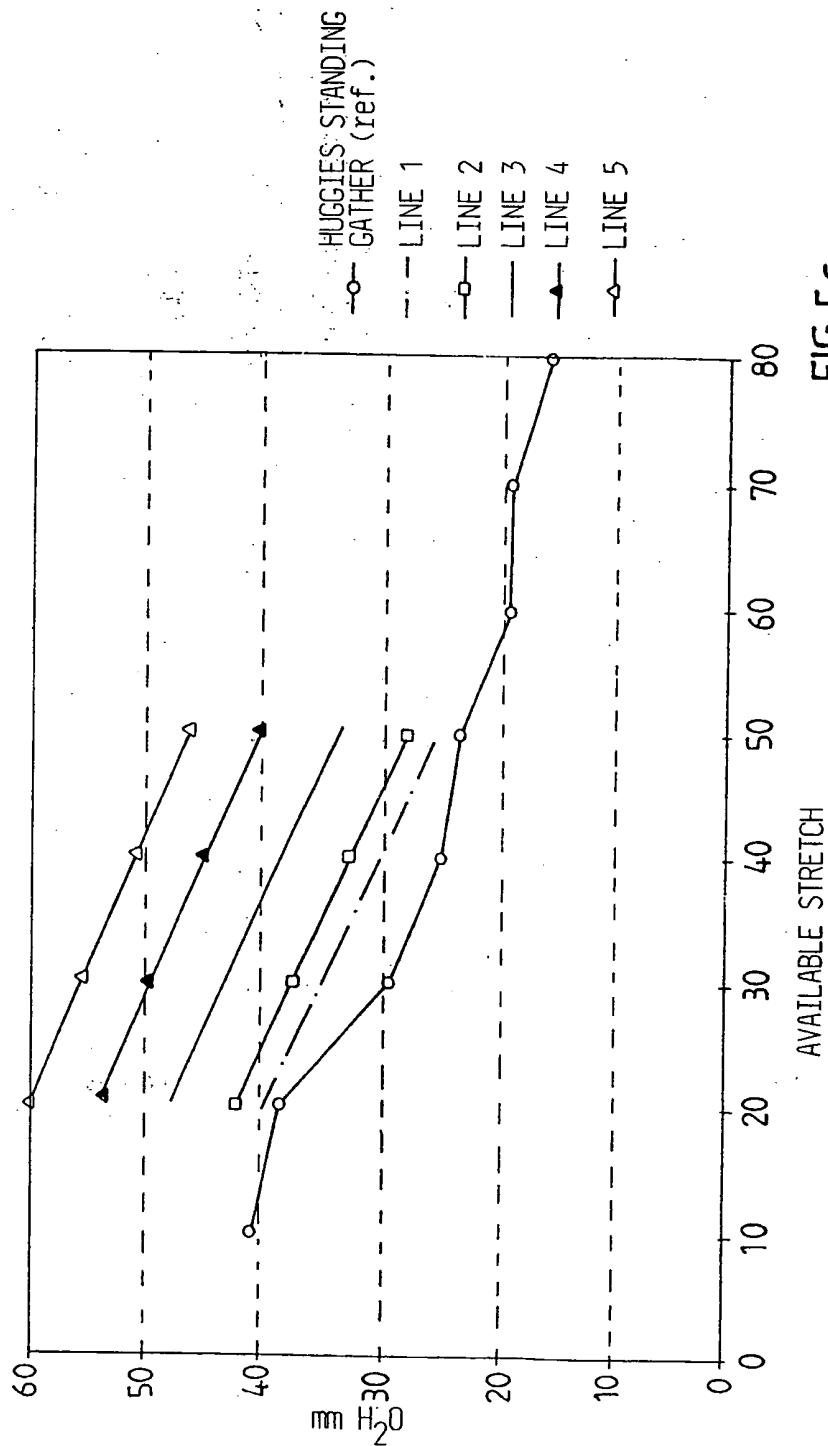


FIG. 5c

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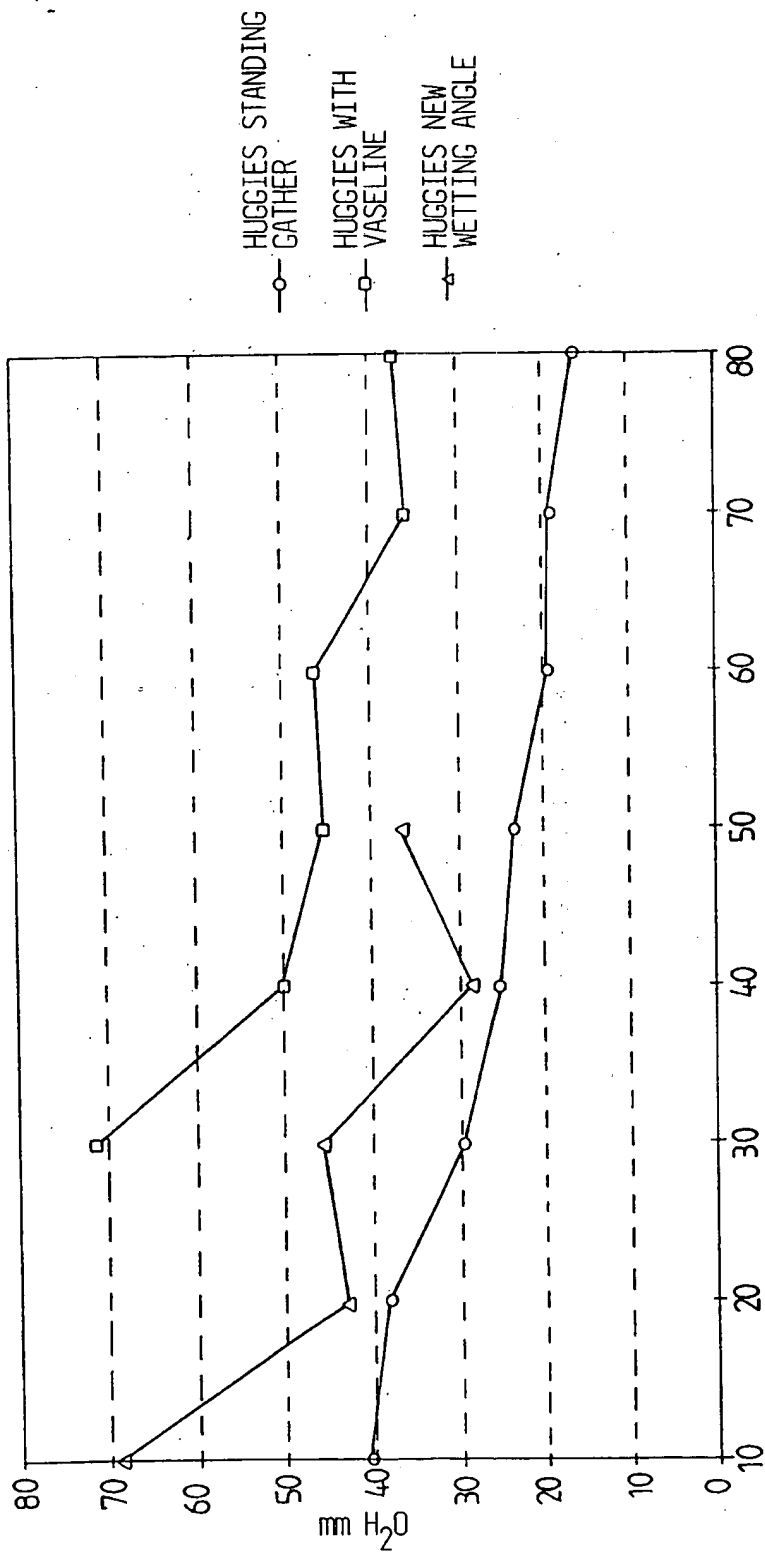


FIG. 6a

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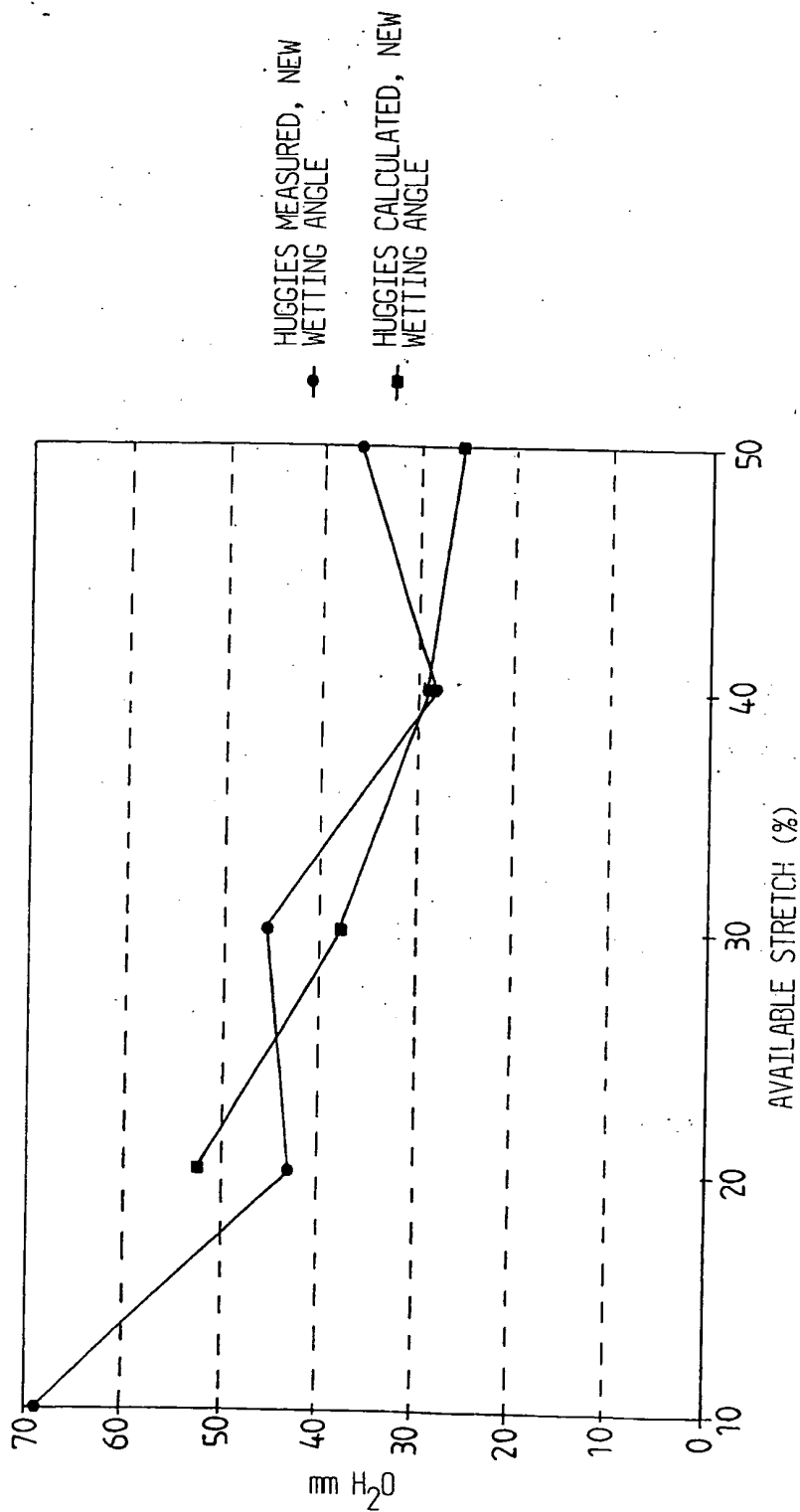


FIG. 6b

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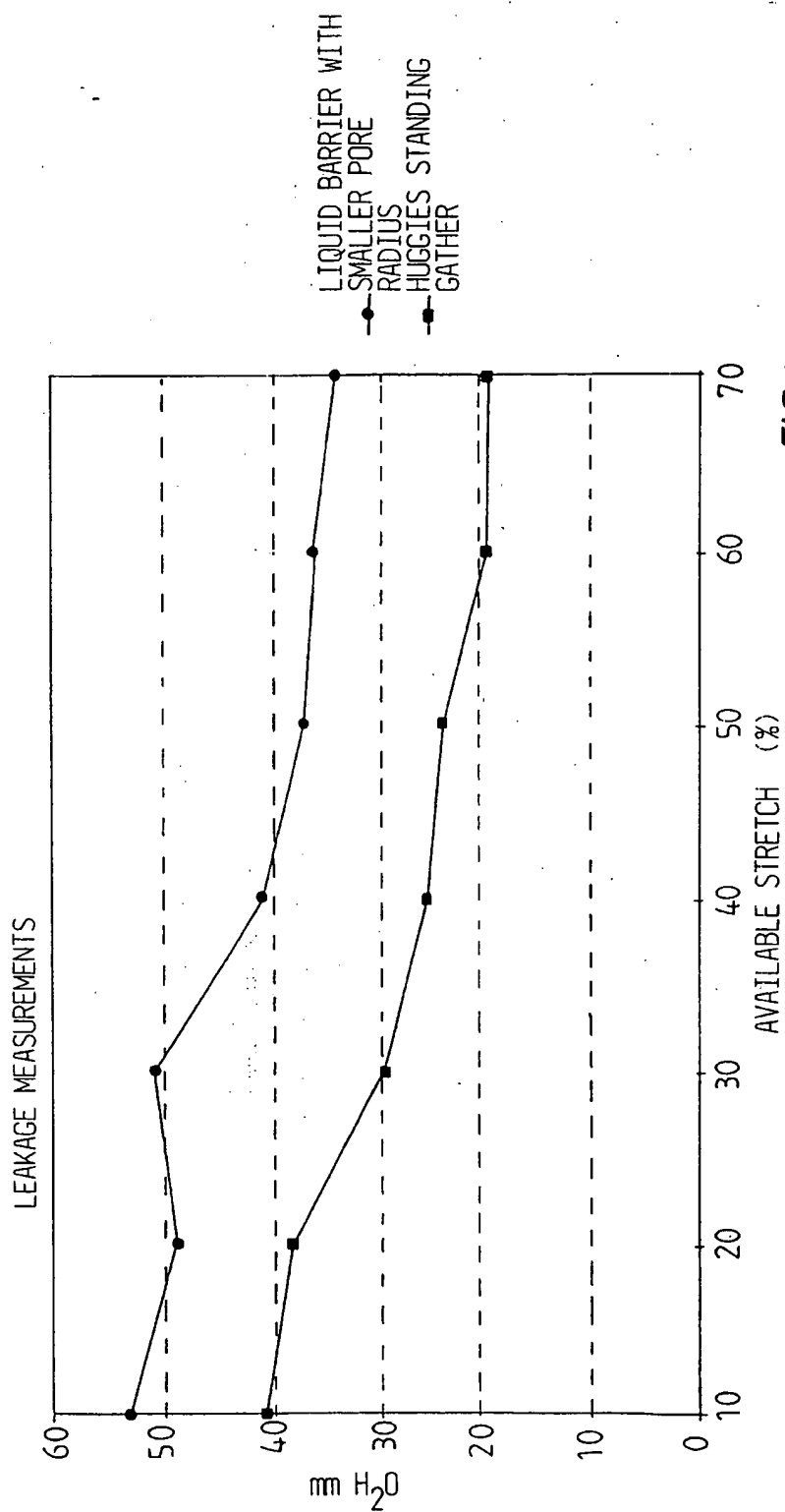


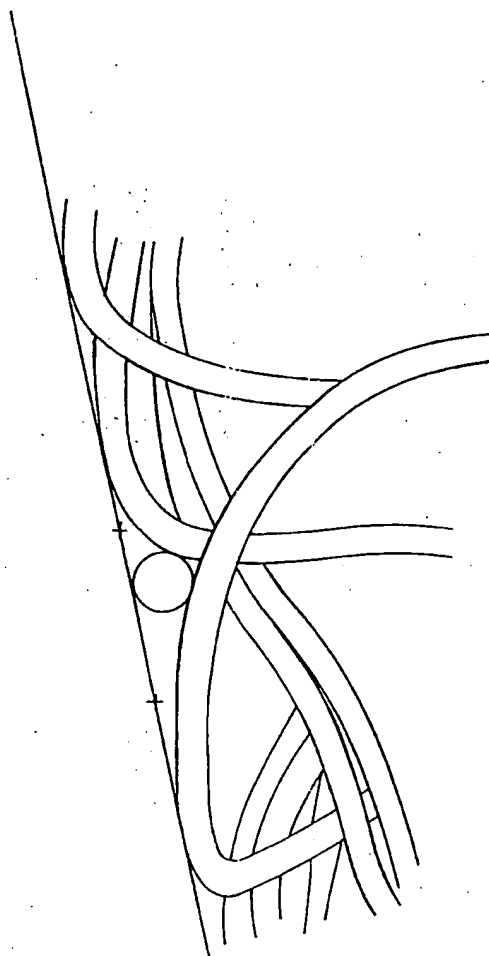
FIG. 7

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FIG. 8

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$$\varnothing = \frac{10}{240} = 0,04176 \text{ mm}$$

$$L_{fil} = 32 \text{ mm}$$

$$L_{fob} = 50 \text{ mm}$$

FIG. 8a

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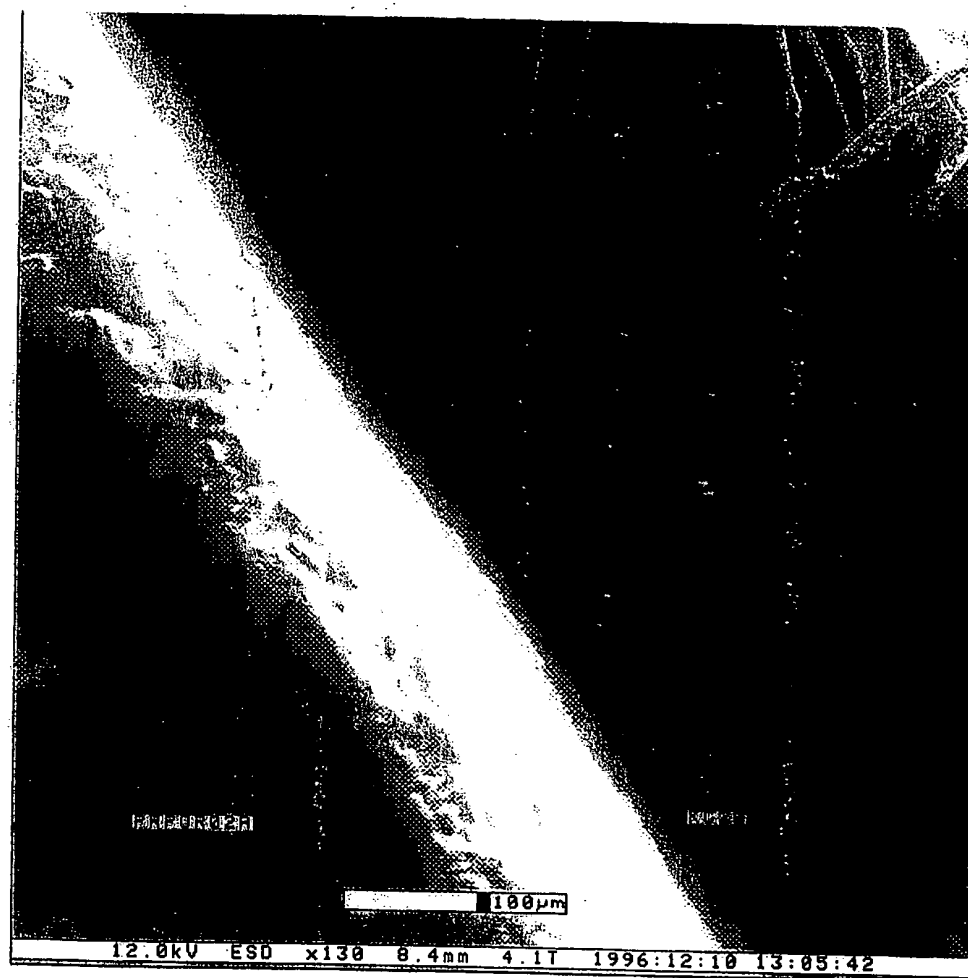


FIG.9

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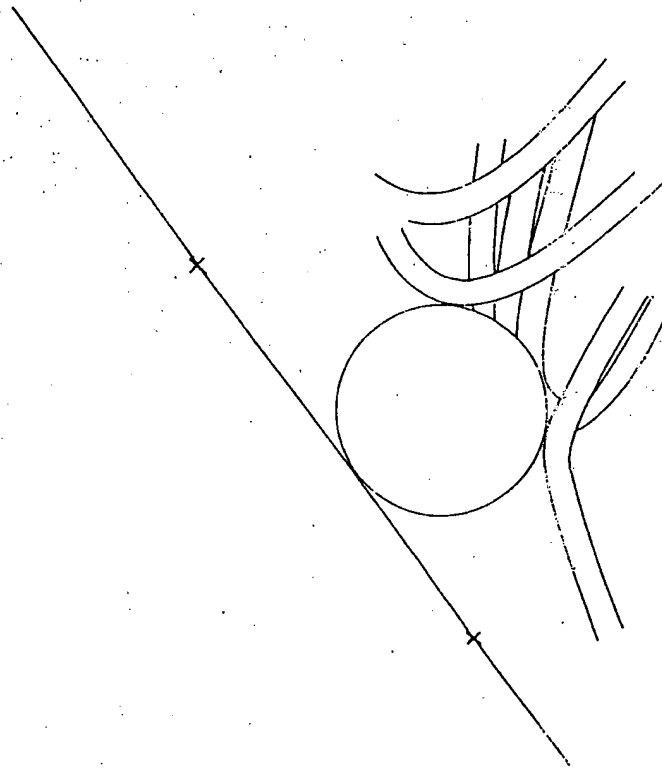


FIG. 9a

$$\varnothing D = \frac{39}{240} = 0.1625 \text{ mm}$$

$$L_{fil} = 83 \text{ mm}$$

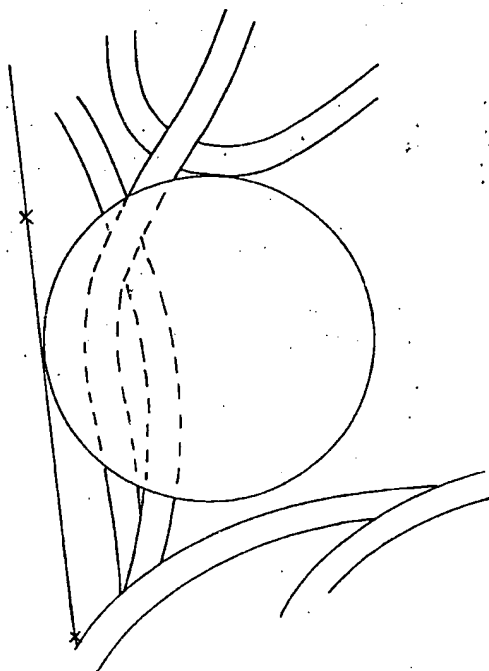
$$L_{fob} = 130 \text{ mm}$$

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FIG. 10

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$$\varnothing D = \frac{58}{240} = 0,24167 \text{ mm}$$

$$L_{fil} = 95 \text{ mm}$$

$$L_{fob} = 205 \text{ mm}$$

FIG. 10a

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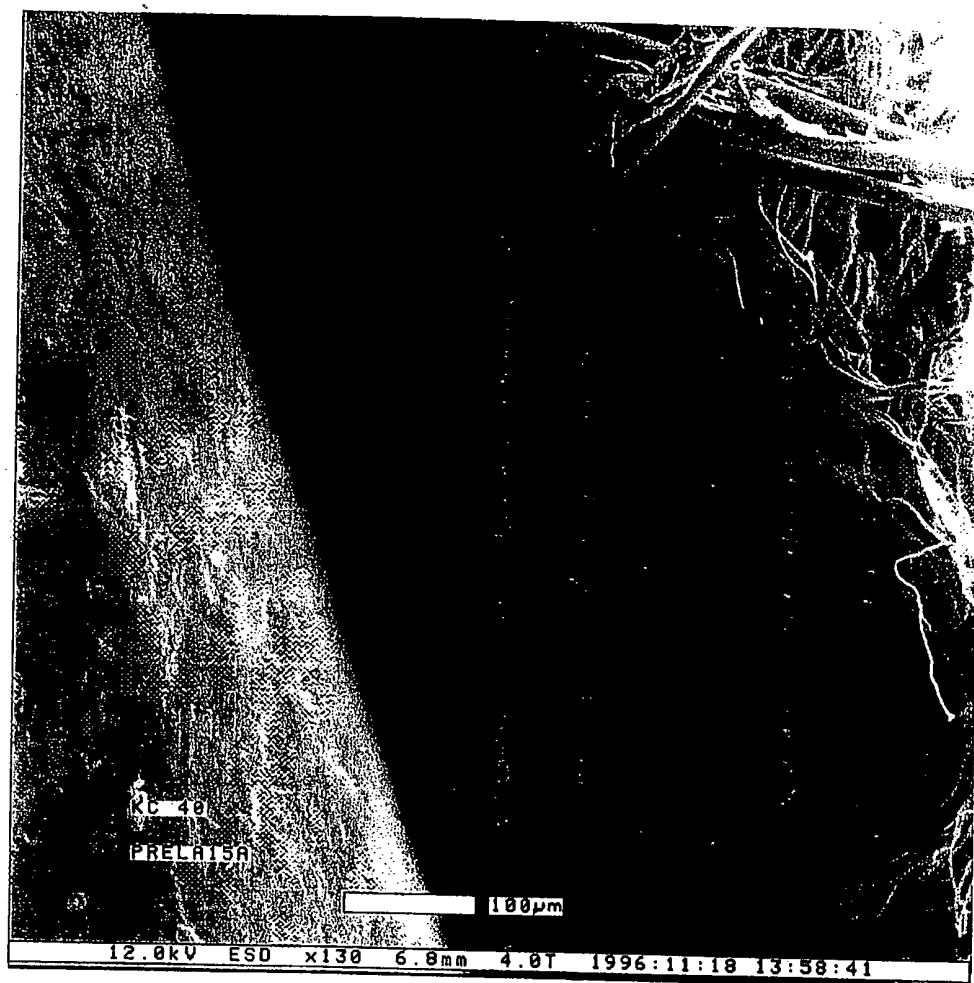


FIG. 11

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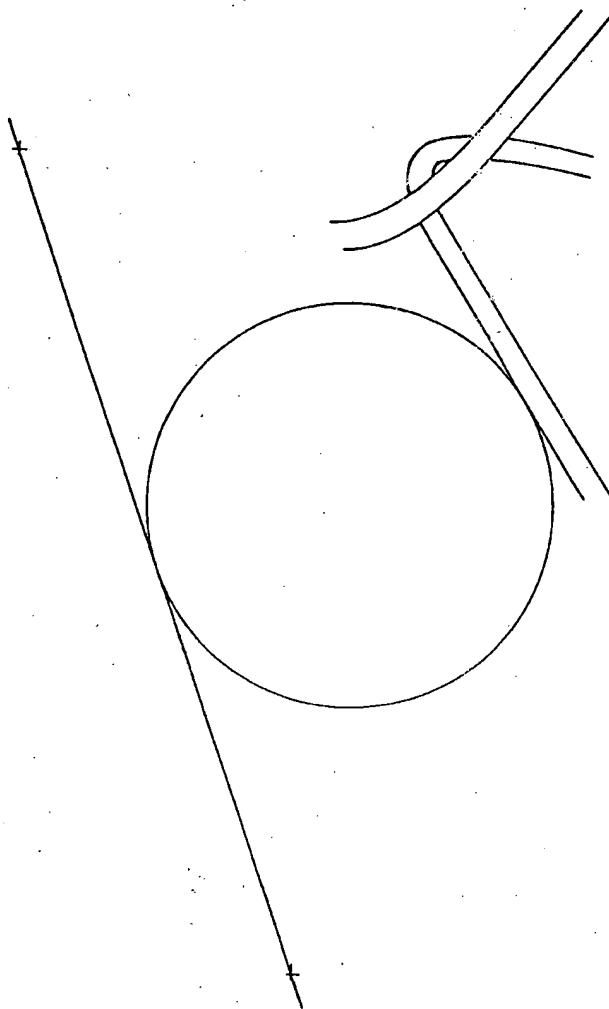


FIG.11a

$$\varnothing D = \frac{70}{240} = 0,29167 \text{ mm}$$

$$L_{fil} = 155 \text{ mm}$$

$$L_{fob} = 245 \text{ mm}$$

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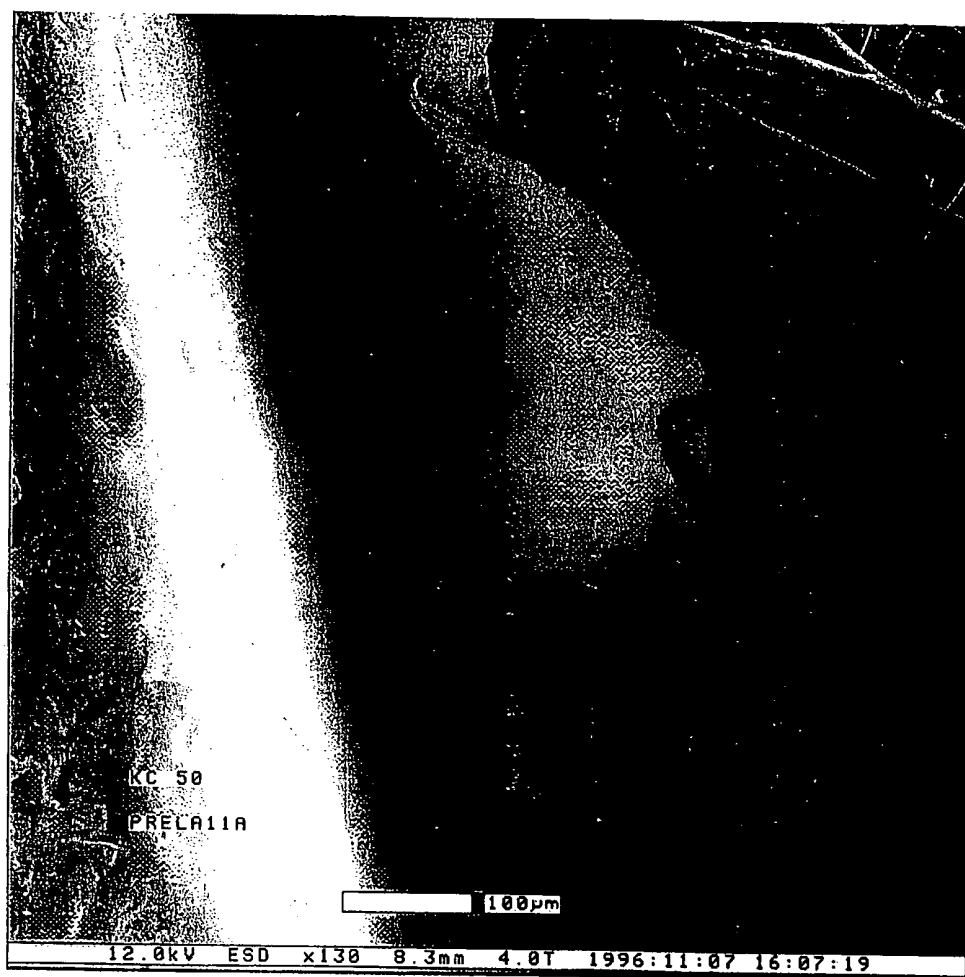


FIG. 12

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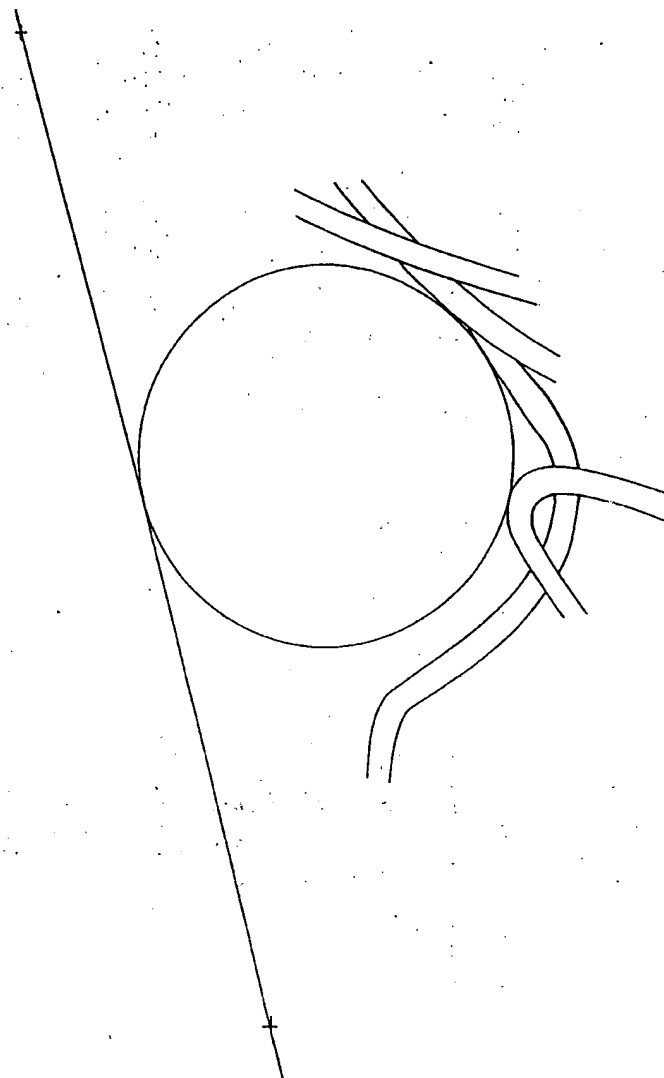


FIG. 12a

$$\varnothing D = \frac{70}{240} = 0,29167 \text{ mm}$$

$$L_{\text{fil}} = L_{\text{fob}}$$

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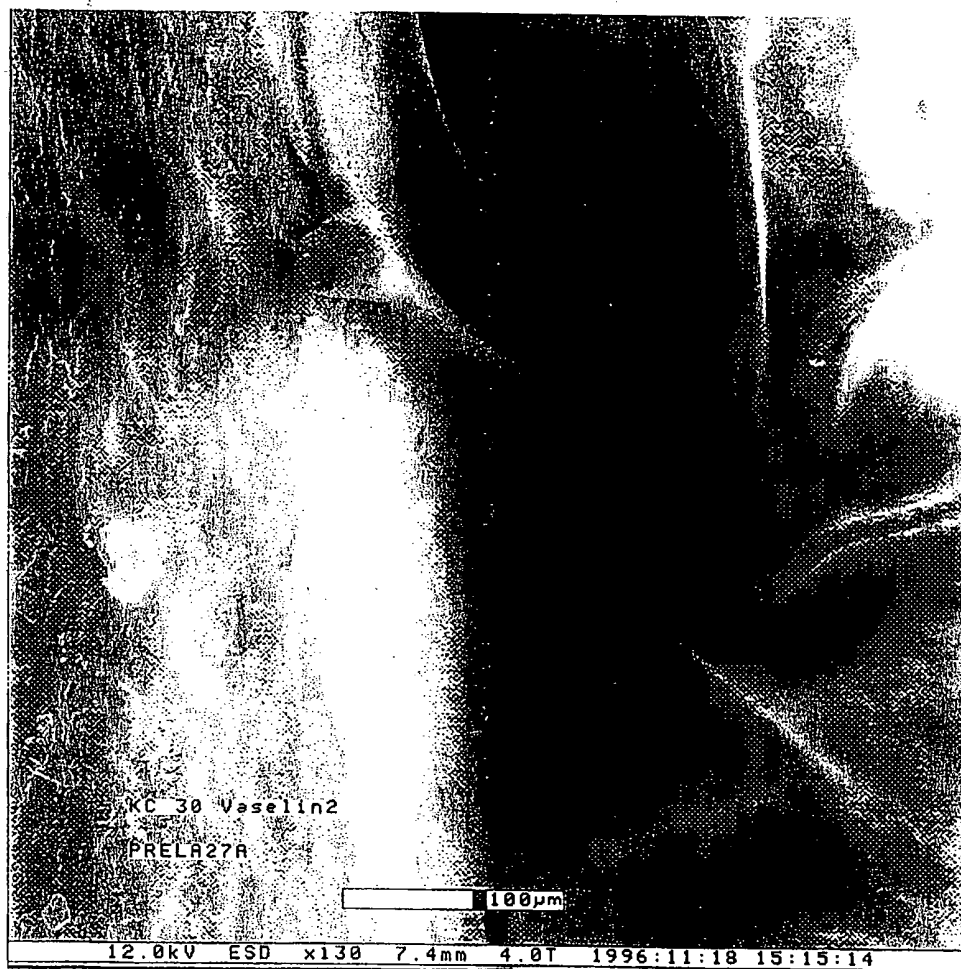


FIG.13

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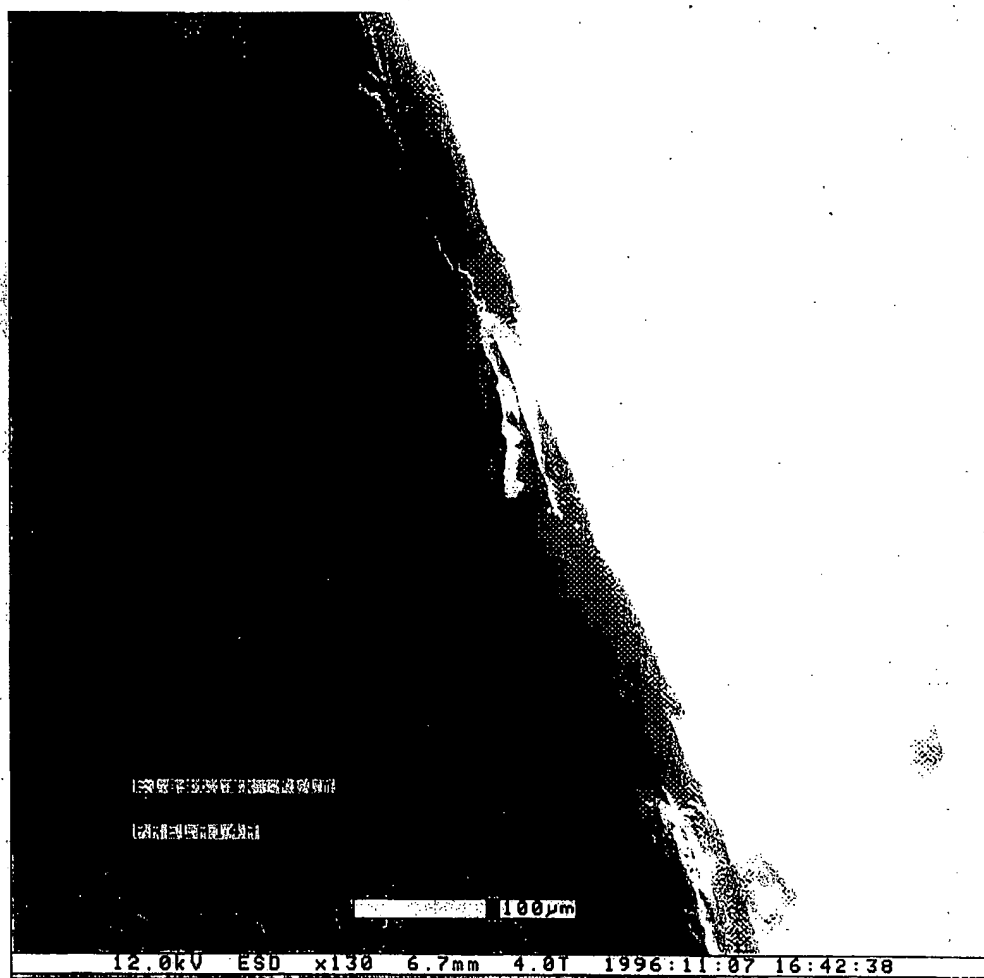


FIG. 14

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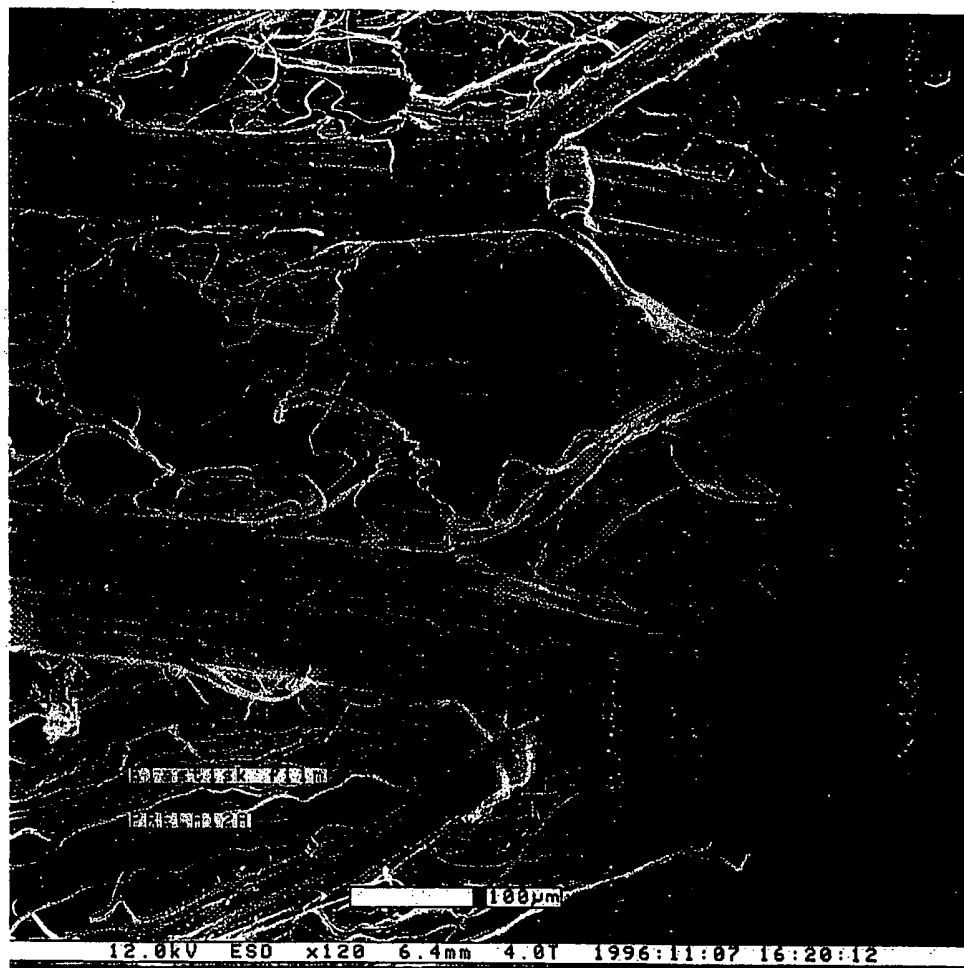


FIG.15

INTERNATIONAL SEARCH REPORT

International application No.

PCT/SE 98/00341

A. CLASSIFICATION OF SUBJECT MATTER

IPC6: A61F 13/15

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC6: A61F

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

SE,DK,FI,NO classes as above

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 5445627 A (SATOSHI MIZUTANI ET AL), 29 August 1995 (29.08.95), figure 3, abstract --	10,12,13
X	EP 0534488 A1 (MCNEIL-PPC, INC.), 31 March 1993 (31.03.93), column 10, line 36 - line 41, figure 9 -- -----	10,15

☐ Further documents are listed in the continuation of Box C.☒ See patent family annex.

* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance

"B" earlier document but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance: the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance: the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

28 May 1998

Date of mailing of the international search report

17 -06- 1998

Name and mailing address of the ISA/

Swedish Patent Office

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Authorized officer

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Telephone No. +46 8 782 25 00

INTERNATIONAL SEARCH REPORT

International application No.

PCT/SE 98/00341

Box I Observations where certain claims were found unsearchable (Continuation of Item 1 of first sheet)

This international search report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claims Nos.:
because they relate to subject matter not required to be searched by this Authority, namely:
2. ☒ Claims Nos.: 1-11, 14, 16
because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:

see next page
3. ☐ Claims Nos.:
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box II Observations where unity of invention is lacking (Continuation of Item 2 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

1. ☐ As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying an additional fee, this Authority did not invite payment of any additional fee.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims for which fees were paid, specifically claims Nos.:
4. ☐ No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

Remark on Protest

- ☐ The additional search fees were accompanied by the applicant's protest.
☐ No protest accompanied the payment of additional search fees.

INTERNATIONAL SEARCH REPORT

International application No.

PCT/SE 98/00341

Claims 1-9 are too broad, because there are too many ways of varying the parameters in the equation " $2\gamma \cos \theta m / r$ ". The claims are also unclear because the increase of the "absolute value of the negative product $2\gamma \cos \theta m / r$ " is not related to any reference value.

Claims 10, 11, 14 and 16 do not relate to an defined absorbent product. The information that the " absolute value of the negative product $2\gamma \cos \theta m / r$ " lies above the line " $y = kx + m$ " relates to desired properties and is not searchable.

According to PCT/Guidelines/2/chapter 3.7 no special efforts need to be made for searching unduly wide and speculative claims, beyond the extent to which they are supported by the description.

Therefore claims 1-11, 14 and 16 are considered unsearchable.

INTERNATIONAL SEARCH REPORT
Information on patent family members

29/04/98

International application No.
PCT/SE 98/00341

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
US 5445627 A	29/08/95	AU 682695 B	16/10/97
		AU 6882694 A	16/02/95
		CA 2129482 A	07/02/95
		CN 2200429 U	14/06/95
		DE 69406608 D	00/00/00
		EP 0638303 A,B	15/02/95
		SE 0638303 T3	
		JP 6227266 A	16/08/94
EP 0534488 A1	31/03/93	SE 0534488 T3	
		AT 145128 T	15/11/96
		AU 666669 B	22/02/96
		AU 684347 B	11/12/97
		AU 2048495 A	03/08/95
		AU 2459492 A	01/04/93
		CA 2077876 A	28/03/93
		CN 1071329 A	28/04/93
		DE 69215181 D,T	17/04/97
		ES 2093751 T	01/01/97
		GR 92100385 A	21/06/93
		HK 16297 A	13/02/97
		HR 920493 A	31/10/95
		HU 69414 A	28/09/95
		JP 7000446 A	06/01/95
		MX 9205498 A	01/04/93
		NZ 244426 A	26/07/95
		PL 169860 B	30/09/96
		SI 9200205 A	31/03/93
		SK 294492 A	12/04/95
		ZA 9207397 A	25/03/94